

WORK INSTRUCTION		
Title: Replacement of Lid Closure and Impact Limiter Attachment Bolts		
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Approved for Use by: <u>Michael R. Brown</u> Effective Date: <u>July 2003</u>		
Applicable Drawings:		
<ul style="list-style-type: none"> • X-106-500-SNP (Sheets 1-9) RH-TRU 72-B Packaging SARP Drawings 		
SARP Requirements:		
<ul style="list-style-type: none"> • Chapter 8.0, Section 8.2.3.1. Threaded fasteners are to be inspected before each use and annually for stripped or deformed threads, and replaced every five years. 		
Tools Required:		
<ul style="list-style-type: none"> • Stainless steel tube brush ($\frac{7}{8}$ and 1-$\frac{1}{4}$-in.) • Calibrated torque wrench (150 lb-ft) • Calibrated torque wrench (650 lb-ft) • 15/16-in. 12-pt socket • $\frac{7}{8}$-in. 6-pt hex-bit • 1-$\frac{1}{2}$-in. 6-pt hex-bit (23-in. long) 		
Spare Parts Required:		
<ul style="list-style-type: none"> • The spare parts are identified in the work instruction steps. All spare parts listed are controlled and shall be recorded on the Maintenance Record. 		
Materials Required:		
<ul style="list-style-type: none"> • Denatured alcohol or equivalent • Lint-free rags 		
Safety Requirements:		
<ul style="list-style-type: none"> • Safety will be observed in accordance with site requirements. 		
Prerequisite Conditions:		
<ul style="list-style-type: none"> • The bolts have been removed from cask and made accessible. 		

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Instruction Steps:

- The spare parts listed below shall be replaced with like-for-like components from the approved spare parts supply.
- The replacement of these parts shall be documented on the Maintenance Record.
- This instruction **is not required to be attached** to the Maintenance Record, but may be used as a checklist during performance of maintenance.

☐ IV Lid Closure Bolt (PN 2078-200-13) PO#_____

☐ IV Lid Closure Bolt Spring (PN 2078-200-14) PO#_____

- 1.0 Clean threads of the insert using $\frac{7}{8}$ -in. tube brush. Wipe clean using alcohol and lint-free rags.
- 2.0 Clean threads of replacement bolt using alcohol and lint-free rags.
- 3.0 Clean spring using alcohol and lint-free rags.
- 4.0 If needed, replace spring by slipping over bolt.
- 5.0 Using the 15/16-in., 12-pt drive socket, install replacement bolt and torque to 100 to 200 lb-ft (record S/N and date due for recalibration of torque wrench on the Maintenance Record)

☐ OC Lid Closure Bolt (PN 2078-300-12) PO#_____

☐ Upper Impact Limiter Bolt (PN 2078-400-10) PO#_____

☐ Lower Impact Limiter Bolt (PN 2078-400-11) PO#_____

- 1.0 Clean threads of the insert using 1- $\frac{1}{4}$ -in. tube brush. Wipe clean using alcohol and lint-free rags.
- 2.0 Clean threads of replacement bolt using alcohol and lint-free rags.
- 3.0 Using a 6-pt hex bit ($\frac{7}{8}$ -in. for OC lid closure bolt and 1- $\frac{1}{2}$ -in. for impact limiter closure bolts), install bolt and torque to 600 to 700 lb-ft (torque will be applied in 220 lb-ft increments) (record S/N and date due for recalibration of torque wrench on the Maintenance Record).

Verification Requirements:

- 1.0 Spare parts used are listed on the Maintenance Record.
- 2.0 Work performed is described on the Maintenance Record.
- 3.0 Work instruction is listed on the Maintenance Record.